

Date:  
User:

Monday, 19/01/2009 2:07:13 PM  
Julie Dawson

# Process Sheet

Dart Aerospace Ltd.

*Split*

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 44908  
Estimate Number : 12806  
P.O. Number :  
This Issue : 19/01/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : SMALL / MED FAB  
Previous Run : 44663  
Written By :  
Checked & Approved By : JLO 09.01.20  
Comment : Est Rev:A New Issue 07-03.26 ec

Drawing Name : BRACKET  
Part Number : D35702  
Drawing Number : D3570 REV.C  
Project Number : N/A  
Drawing Revision : C  
Material :  
Due Date : 10/02/2009 Qty: 12 ~~6~~ Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.4473 sf(s)

6061-T6 .125 Sheet

Batch: 110405

HB 9-2-10

\*\*\*Grain must be Along 4.63\*\*\*\*\*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: B

Prog Rev: B

HB 9-2-10

(14)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-2-10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/02/10

(14)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

ff


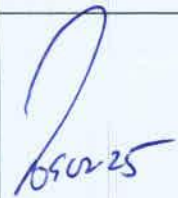
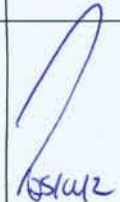
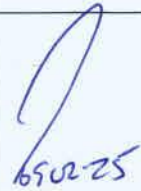
09/02/17

P10

(14)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-2 PAR #: N/A Fault Category: Prod/Passy media small NCR: Yes No DQA: 12 Date: 09/03/03  
 Resolution: D42-702-113 SCRAP Disposition: SCRAP QA: N/C Closed: 12 Date: 09/03/03

NCR: 44908		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/17	5	1 Bracket D35702 Hole Drilled before Finishing off Radius of Lip.	 05/02/17	Scrap & Destroy no replacement.	09/02/17 EF	 05/02/25	 05/02/25	 05/02/25

NOTE: Date & initial all entries



Date: Monday, 19/01/2009 2:07:13 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44908

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09/02/17 (14)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/02/25 (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mo/BK

(11) 09/02/25

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

9/1 09-02-26

(11)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-02-26

(11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 245A

SS 09/02/26 (11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26 (11)

Job Completion



09/02/26

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

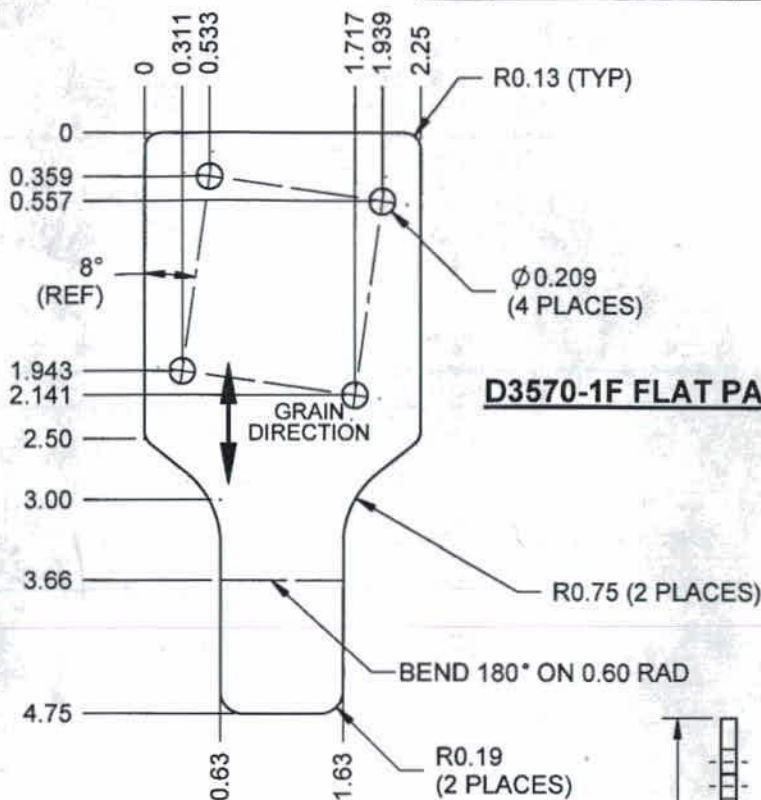








DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET		SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	



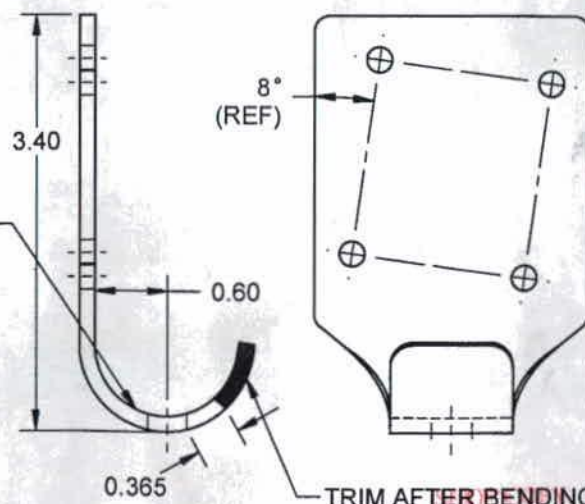
RELEASED

07.06.01 *H*

**D3570-1F FLAT PATTERN**

**D3570-1 BRACKET SHOWN  
(MAKE FROM D3570-1F)**

**D3570-2 BRACKET OPPOSITE  
(MAKE FROM D3570-1F)**



**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44908

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